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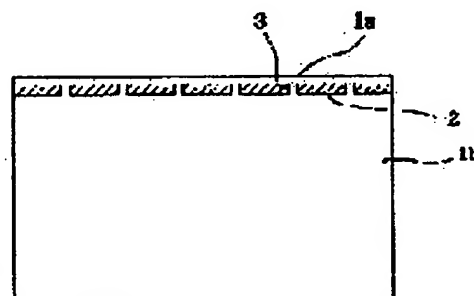
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(54) COMPOSITE INJECTION MOLDED ARTICLE

(57)Abstract:

PROBLEM TO BE SOLVED: To obtain strong integration force between a resin and an insert material, to be free from wrinkles and breakage, to have electromagnetic wave shielding properties, and to enable three-dimensional molding by covering part of the cloth surface of an insert material with a thermoplastic resin continuous with a thermoplastic resin on the back side through the meshes of the cloth.

SOLUTION: On the surface side of the cloth 2 of a sheet of insert material such as a cotton nobinder nonwoven fabric having nearly equal elongation multi-directionally and heat resistance, a low melting point metal material which can be melted during the heating of a mold as a conductive material is stuck continuously and arranged in the mold. A molten thermoplastic resin 1b is injected/packed from the back side of the cloth 2, heated with the cloth 2 pressed to the inner surface of the mold, pushed out to the surface side through the meshes 3 of the cloth 2 to cover the surface partially or entirely, cooled, and integrated mechanically with the cloth 2. In this way, the cloth 2 can be molded along a three-dimensional shape without generating peeling, wrinkles, and breakage to be an article having high electromagnetic wave shielding properties.



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